

Work Order ID 155034

Thursday, January 05, 2017 11:51:02 AM

155034

Page 1

Item ID: D412-698-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Door Track, Aluminum Door

Start Date: 1/25/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/1/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JAN 06 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-017CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

FEB 14 2017

DAS
6
9-89DAS
21
9-89

17-02-15

DAS
27
9-89

FEB 21 2017

FEB 16 2017

DAS
28
9-89DAS
27
9-89

FEB 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155034***155034***

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Thursday, January 05, 2017 11:51:02 AM

Item ID: D412-698-017 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Door Track, Aluminum Door
Start Date: 1/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/1/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					DAS 27 9-89			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-017 Location: <u>fg 034</u> PPP Rev: _____					FEB 21 2017			
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89	FEB 21 2017	
QC	Memo	0.02							
Quality Control									

FEB 21 2017

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Work Order ID: 155034

155034

Parent Item: D412-698-017

D412-698-017

Parent Item Name: Replacement Door Track, Aluminum Door

Start Date: 1/25/2017

Required Date: 2/1/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A03.11.27New issueKJ/RF
IPP Rev:B 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3199-1
D3199-1
Bracket

Manufactured No

Each 24.0000

9

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST022

24

150925

24

D3202-1
D3202-1
Cover

Manufactured No

Each 10.0000

1

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST195a

10

147812

10

DAS
6
9-89

DAS
28
9-89

FEB 16 2017

DAS
6
9-89

DAS
28
9-89

FEB 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 155034***155034***

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Tuesday, February 14, 2017 11:57:07 AM

Item ID: D412-698-017**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Replacement Door Track, Aluminum Door**Start Date:** 1/25/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 2/1/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						21 21		
IIN D412-698	F						9-89	FEB 15 2017	

100 Document Control 0.00

100

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D412-698-017CHG001

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120

QC Memo 0.00

Quality Control

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW